

**Work Order ID 64499**

Tuesday, December 07, 2010 8:51:57 AM

Page 1

Item ID: D4114-2

Accept

Revision ID:

Item Name: Door Doubler, RH

Start Date: 12/7/2010 Start Qty: 4.00

Required Date: 12/20/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:   H  Date: 10-12-7

Tooling:

Date:

QC:           Date:           SPC (Y/N):           Date:           

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4114

A

100

0.00



Waterjet

FLOW CNC Waterjet

304.063

Memo

1-Cut as per Dwg

Dwg Rev:   A  Prog Rev:   1  

2-Deburr if necessary

B10-12-16

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 64499

Tuesday, December 07, 2010 8:51:57 AM



Page 2

Item ID: D4114-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, RH

Start Date: 12/7/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/12/16

(x4)

130

Memo

0.00



Small Fab

Small Fab

1- C'sink holes as per dwg

0.00

8/30/12/17 (4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/17

(x4)

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**NOTE:** Date & initial all entries

**Work Order ID 64499**

Tuesday, December 07, 2010 8:51:57 AM

Page 3

Item ID: D4114-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Doubler, RH

Start Date: 12/7/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: B30

0.00



Packaging

Memo

0.00

Packaging

10/12/17 *sf*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/2017  
*MUF*  
10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, December 07, 2010 8:52:03 AM

Page 1

Work Order ID: 64499

Parent Item: D4114-2

Parent Item Name: Door Doublet, RH



Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

124.0000

0.25

1.052632



304/316 Sheet .063



1810-12-16

Location

Loc Qty

Loc Code

MAT

124

111323

0

115953

124

115953

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 64499
Description: Door Doubler RH.		Part Number: D4114-2
Inspection Dwg: D4114-2, Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.128	X		VIB02	
Ø .375	+ .006 - .001	.375	X		V	
.25	± .030	.251	X		V	
2.250	± .010	2.256	X		V	
1.125	± .010	1.125	X		V	
2.75	± .030	2.752	X		V	
.254	± .010	.252	X		V	
.508	± .010	.508	X		V	
6.00	± .030	6.011	X		V	
.75	± .030	.754	X		V	
.25	± .030	.251	X		V	
5.50	± .030	5.502	X		V	
1.10	± .030	1.098	X		V	
6.00	± .030	6.008	X		V	
.64	± .030	.645	X		V	
1.38	± .030	1.382	X		V	
2.20	± .030	2.205	X		V	
.75	± .030	.746	X		V	
3.30	± .030	3.298	X		V	
1.10	± .030	1.098	X		V	
.063	± .010	.058	X		V	

Measured by: IB
Date: 10-12-16

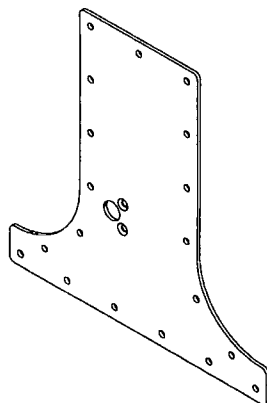
Audited by: S
Date: 10/12/16

Prototype Approval:
Date:

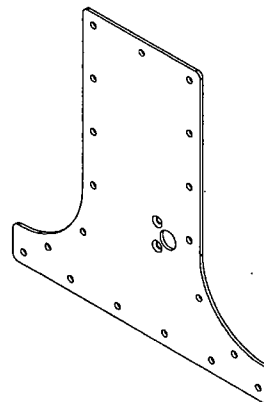
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 64499

*BS-127*



D4114-1 DOOR DOUBLER, LH



D4114-2 DOOR DOUBLER, RH

**RELEASED**  
 2010-09-23

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4114</b> TITLE <b>DOOR DOUBLER</b> SCALE <b>NTS</b>	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DATE <b>10.07.20</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

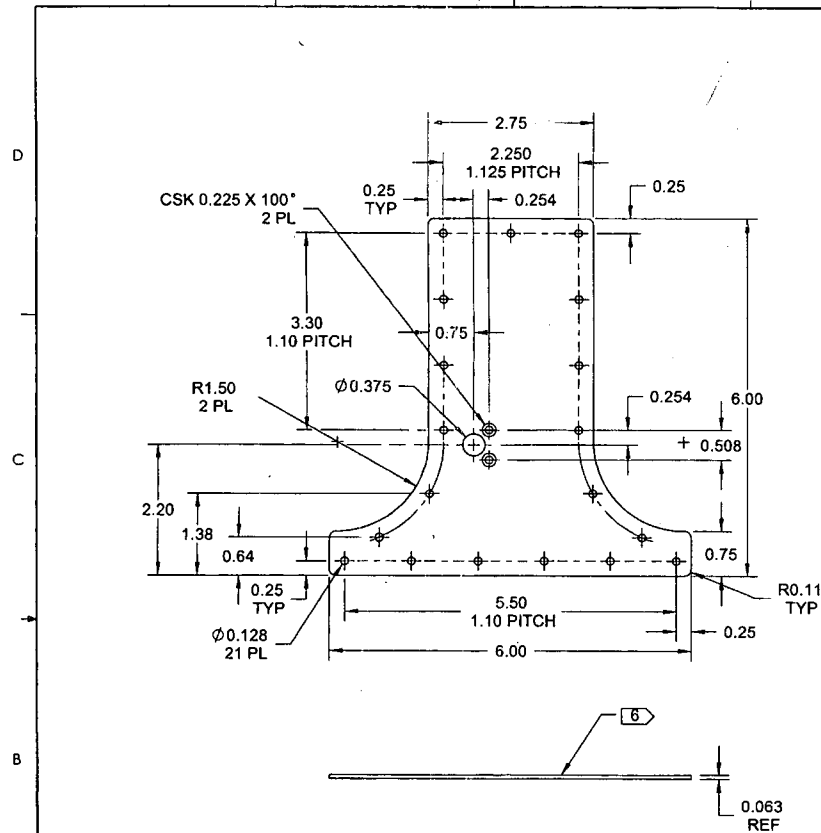
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

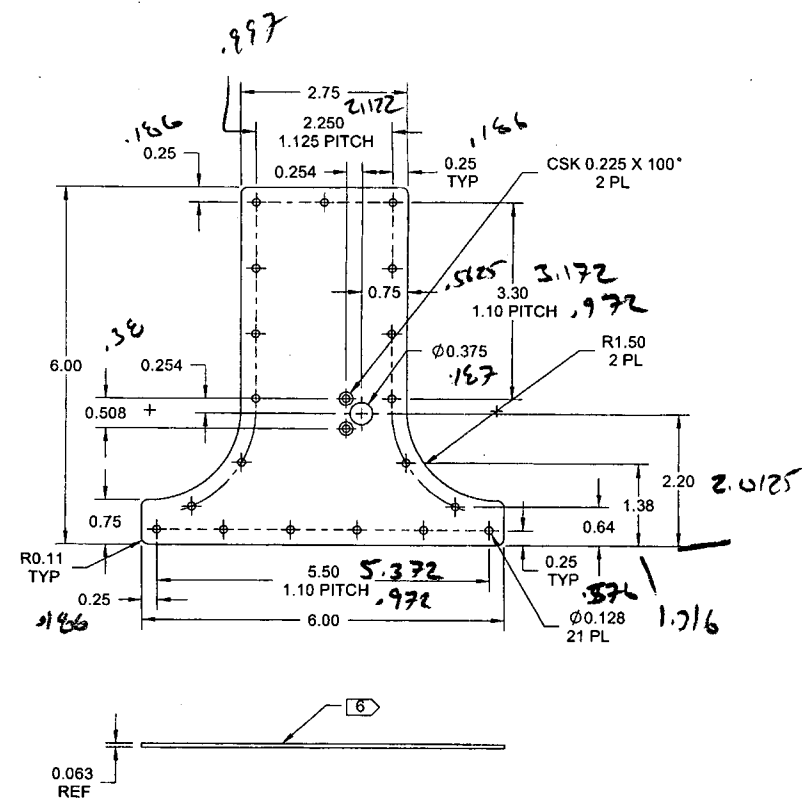
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4114-1 DOOR DOUBLER, LH**



**D4114-2 DOOR DOUBLER, RH**

**NOTES:**

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4114-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.35 lbs

*wb64499*

**RELEASED**  
R 2010-09-23  
MN

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. <b>D4114</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE <b>DOOR DOUBLER</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.07.20		

8 7 6 5 4 3 2 1

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